THOMPSON/CENTER
A Smith & Wesson® Company

Safety & Instruction Manual

T/C Venture™ Bolt Action Rifle

Read the instructions and warnings in this manual CAREFULLY BEFORE using this firearm.

THOMPSON/CENTER ARMS CO., INC.
400 North Main Street
Rochester, NH 03867
TEL. 1-603-330-5659
www.tcarms.com

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WARNING

READ THESE INSTRUCTIONS AND WARNINGS CAREFULLY. BE SURE YOU UNDERSTAND THESE INSTRUCTIONS AND WARNINGS BEFORE USING THIS FIREARM. FAILURE TO READ THESE INSTRUCTIONS AND TO FOLLOW THESE WARNINGS MAY RESULT IN SERIOUS INJURY OR DEATH TO YOU AND OTHERS AND DAMAGE TO PROPERTY

This SAFETY & INSTRUCTION MANUAL should always accompany this firearm and be transferred with it upon change of ownership or when the firearm is presented to another person.

Always keep your firearm pointed in a safe direction. Never point a firearm at anything you do not intend to shoot.

If you don't have a manual, printed copies are available free upon request by contacting the factory at the address below. They are also available via download from the company's web site shown below.

THOMPSON/CENTER ARMS CO., INC.
• CUSTOMER SUPPORT •
400 NORTH MAIN STREET
ROCHESTER, NH 03867
TEL.: 1-603-330-5659
www.tcarms.com

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YOUR SAFETY RESPONSIBILITIES

SAFETY IS YOUR NUMBER ONE RESPONSIBILITY!!!!

At home, in the field, at the range, or anywhere, the first concern of every firearm owner should be safety. Apply the following safety rules in every situation, with any kind of firearm. If you feel uncertain about any operational aspects of your firearm, please contact Thompson/Center before proceeding with its operation.

WARNING: YOU MUST FOLLOW ALL OF THESE SAFETY RULES TO ENSURE THE SAFE USE OF YOUR FIREARM. THE FAILURE TO FOLLOW THE INSTRUCTIONS AND WARNINGS IN THIS MANUAL COULD CAUSE SERIOUS PERSONAL INJURY OR DEATH TO YOU OR OTHERS AND DAMAGE TO PROPERTY.

As a gun owner, you accept a demanding responsibility. How serious you take this responsibility can be the difference between life and death. There is no excuse for careless or abusive handling of your firearm. At all times handle your firearm with intense respect for its power and potential danger.

- **ALWAYS KEEP YOUR FIREARM POINTED IN A SAFE DIRECTION.** Never point a firearm at anyone or anything you do not intend to shoot whether or not it is loaded. This is particularly important when loading, unloading, or field stripping the gun. ALWAYS control the direction of the firearm.

- **ALWAYS TREAT EVERY FIREARM AS IF IT IS LOADED AND WILL FIRE.** Do not take anyone's word that the firearm is unloaded – always check for yourself. Never pass your firearm to another person until the action is open and you visually check that it is unloaded. Keep your firearm unloaded and safely stored when not in use.

- **NEVER PLACE YOUR FINGER INSIDE THE TRIGGER GUARD OR ON THE TRIGGER UNLESS YOU INTEND TO FIRE.** Ensure that other objects do not touch the trigger.

- **ALWAYS BE SURE OF YOUR TARGET AND WHAT IS BEYOND IT.** Always be sure of where the bullet will strike and shoot only where there is a safe back stop free of obstructions, water or other surfaces which can cause ricochets. Be sure your bullet will stop behind your target. Bullets can glance off many surfaces like rocks or the surface of water and travel in unpredictable directions with considerable velocity. Do not fire randomly into the sky.

- **NEVER CROSS OBSTACLES SUCH AS FENCES OR STREAMS WITH A LOADED FIREARM.** Always make certain your firearm is unloaded before crossing a fence, climbing a tree, jumping a ditch or negotiating other obstacles.

- **SAFE GUN HANDLING IS YOUR PERSONAL RESPONSIBILITY AT ALL TIMES.** Firearms are dangerous and can cause serious injury or death if they are misused or used inappropriately. Safety must be the prime consideration of any one who owns or handles firearms. Accidents are the result of violating the rules of safe gun handling and common sense. Firearm safety training is available. Contact your firearms dealer, law enforcement agency, local sportsman's club, etc. for availability.

- **YOU ARE RESPONSIBLE FOR THE FIREARM AT ALL TIMES.** In owning a firearm, you must undertake full-time responsibility for your firearm's safety and security. You must protect yourself and all others against injury or death from misuse of the firearm 24 hours a day.

- **FIREARM SECURITY IS YOUR RESPONSIBILITY.** You must secure firearms safely from children and/or unauthorized users. Your firearm should always be kept unloaded and locked when not in use. Never assume that the use of this lock is sufficient to safely secure your firearm. You must always evaluate your personal situation and employ the security systems that meet your needs and prevent children and unauthorized users from gaining access to your firearm.

- **APPROPRIATE USE FOR YOUR FIREARM MEANS USING YOUR FIREARM FOR LEGAL PURPOSES.** For example - target shooting, hunting and lawful resistance of deadly criminal force. It is your responsibility to ensure that you are in compliance with all applicable laws and ordinances regarding the use of your firearm.

- **NEVER RELY ON MECHANICAL FEATURES ALONE.** Only your safe gun-handling habits will ensure the safe use of your firearm. This is your responsibility.

- **ALWAYS SAFELY STORE AND SECURE YOUR FIREARM.** Safe and secure storage of your firearm is one of your most important responsibilities. It is a full-time responsibility. You must always secure your firearm and ammunition separately so that they are not accessible to children and/or other unauthorized persons.

- **NEVER KEEP AMMUNITION IN THE SAME LOCATION AS THE FIREARM.** Store each in a separate and secure place.

- **ALWAYS WEAR EYE PROTECTION THAT IS SPECIFIED FOR USE WITH FIREARMS** every time you handle your firearm for cleaning and maintenance.

- **ALWAYS WEAR EYE AND EAR PROTECTORS THAT ARE SPECIFIED FOR USE WITH FIREARMS** every time you discharge your firearm. Make sure others in the vicinity of where you will be shooting do so as well.

- **NEVER USE ALCOHOL OR DRUGS BEFORE OR WHILE SHOOTING.** Do not use your firearm if you are on any medication which impairs, even slightly, your mental or physical ability.

- **ALWAYS HAVE ADEQUATE VENTILATION.** Discharging firearms in poorly ventilated areas, cleaning firearms, or handling ammunition may result in exposure to lead and other substances known to cause birth defects, reproductive harm, and other serious physical injury. Review the warnings and labels for all ammunition and cleaning products carefully. Wash hands thoroughly after exposure.

- **BEFORE HANDLING ANY FIREARM, UNDERSTAND ITS OPERATION.** Not all firearms are the same. Familiarize yourself with the mechanical features of any firearm you intend to use. If you feel uncertain about any operational aspects of your firearm, please contact Thompson/Center, before proceeding with its operation.

- **NEVER ALLOW A FIREARM TO BE USED BY INDIVIDUALS WHO DO NOT UNDERSTAND ITS SAFE OPERATION OR HAVE NOT READ THESE FIREARM SAFETY RULES.**

- **ALWAYS USE THE CORRECT AMMUNITION FOR YOUR PARTICULAR FIREARM** as indicated by the marking on the firearm. Never use non-standard, reloaded, or "handloaded" ammunition which has not been subjected to internal ballistic pressure testing.

- **BEWARE OF BARREL OBSTRUCTIONS** Be sure the barrel is clear of obstructions before shooting. Mud, water, snow or other objects may inadvertently lodge in the barrel bore. A small obstruction can cause a dangerous increase in pressure and may damage your gun and cause injury to yourself and others.

- **BE SURE ALL ACCESSORIES, SUCH AS HOLSTERS. GRIPS, SLINGS, SCOPES AND OTHER ACCESSORIES ARE COMPATIBLE** with the firearm and that the accessories do not interfere with safe operation. It is your responsibility to understand and follow all of the instructions in this manual,as well as those which may be supplied with your ammunition and any accessory.

- **NEVER DISASSEMBLE YOUR FIREARM** beyond the field stripping procedure outlined in this manual. Improper disassembly or reassembly of your firearm may be dangerous and can lead to serious injury or death.

- **NEVER MANIPULATE, ADJUST OR CHANGE ANY OF THE INTERNAL COMPONENTS OF YOUR FIREARM UNLESS SPECIFICALLY INSTRUCTED TO DO SO IN THIS MANUAL.** Improper manipulation of any other internal component may affect the safety and reliability of your firearm and may cause serious injury or death.

- **NEVER ALLOW ANY ALTERATION OR REPLACEMENT OF PARTS IN YOUR THOMPSON/CENTER FIREARM UNLESS PERFORMED BY A QUALIFIED GUNSMITH** using genuine Thompson/Center parts. If you do otherwise, improper functioning of your firearm may occur and serious injury or death and damage to property may result.

WARNING: SAFE USE OF A FIREARM IS YOUR PERSONAL RESPONSIBILITY AND THE FAILURE TO FOLLOW ALL OF THESE BASIC SAFETY RULES MAY RESULT IN SEVERE PERSONAL INJURY OR DEATH TO YOU OR OTHERS. YOU ARE THE MOST IMPORTANT SAFETY DEVICE WHEN IT COMES TO THE USE OF YOUR FIREARM AND THOMPSON/CENTER AND ITS PARENT COMPANY WILL NOT BE RESPONSIBLE FOR ANY PERSONAL INJURY, DEATH OR PROPERTY DAMAGE THAT RESULTS FROM: (1) THE CRIMINAL OR NEGLIGENT USE OF THIS FIREARM; (2) A DISREGARD OF THESE SAFETY INSTRUCTIONS AND WARNINGS; (3) IMPROPER OR CARELESS HANDLING OF THIS FIREARM; (4) THE USE OF NON-STANDARD, DEFECTIVE, IMPROPER OR RELOADED AMMUNITION; OR (5) IMPROPER OR NEGLIGENT MODIFICATIONS OR REPAIRS TO THE FIREARM.

SAFE STORAGE & TRANSPORTATION

WARNING: ALWAYS POINT THE MUZZLE IN A SAFE DIRECTION.

WARNING: FIREARMS ARE DANGEROUS WHEN USED AND STORED IMPROPERLY. THEY POSE A RISK OF SERIOUS OR FATAL INJURIES. FIREARMS CAN BE ESPECIALLY DANGEROUS TO CHILDREN WHEN THEY ARE STORED IN AN IRRESPONSIBLE AND UNSAFE MANNER. FOR YOUR SAFETY AND THE SAFETY OF OTHERS, IT IS IMPERATIVE THAT YOU KEEP YOUR FIREARM LOCKED AND UNLOADED IN A SECURE PLACE. THE AMMUNITION SHOULD BE STORED IN A SEPARATE, SECURE LOCATION WHEN IT IS NOT IN USE. SAFE AND SECURE STORAGE OF YOUR FIREARM IS ONE OF THE MOST IMPORTANT RULES OF FIREARM SAFETY. YOUR FAILURE TO FOLLOW THESE RULES MAY RESULT IN SERIOUS INJURY OR DEATH TO YOU OR OTHERS.

- **ALWAYS SECURE YOUR FIREARM IN A MANNER THAT WILL PREVENT UNAUTHORIZED ACCESS.** Whenever your firearm is not in use, keep it unloaded and locked. Your safety and the safety of others requires that you always secure and store your firearm in a manner that will prevent unauthorized access. Never leave a firearm unattended unless it is locked, unloaded and secured.

- **ALWAYS USE THE LOCK PROVIDED BY THOMPSON/CENTER TO SECURE YOUR FIREARM.** Please read and follow the instructions packaged separately for the use of this lock. A lock, when properly used, can be an effective tool in preventing unauthorized access to your firearm. There are other alternative locks and safe storage containers available in the marketplace which may also be appropriate for your particular needs. Consult your local gun shop, hardware store, or local police department for guidance on the variety of other safe storage devices or practices which may be appropriate for your particular needs. By purchasing this firearm you have accepted the responsibility of safely securing the firearm at all times and preventing its unauthorized use. Never assume that the use of this lock alone is sufficient to safely secure your firearm. It is your personal responsibility to select and use whatever measures or practices that will enable you to be absolutely certain that your firearm is secure at all times.

WARNING: NEVER LOCK A LOADED FIREARM AND NEVER LOAD A LOCKED FIREARM!!

SAFE STORAGE & TRANSPORTATION CONT'D

- **ALWAYS STORE YOUR FIREARM AND AMMUNITION SEPARATELY** so that they are not accessible to children or other unauthorized persons. Safe and secure storage of your firearm and ammunition are your responsibility. It is a full-time responsibility.

- **NEVER ASSUME THAT A "HIDING" PLACE IS A SECURE STORAGE METHOD.** Others may be aware of your storage location or come upon it by chance. It is your personal responsibility to use common sense when storing your firearm and ammunition and to always make sure they are not accessible to children or other unauthorized persons.

- **NEVER TRANSPORT A LOADED FIREARM.** When transporting your firearm, be sure it is unloaded and locked. Safe and secure transportation of your firearm is your responsibility.

- **ALWAYS FOLLOW THE LAW!** Many jurisdictions have laws that make it a crime to keep a firearm unlocked and in an area accessible to children or others. Keeping a firearm locked and unloaded when not in use is not only common sense safety practice... IT IS THE LAW. You must be familiar with all local, state, and federal laws regarding the safe storage and transportation of your firearm. Failure to know and follow the law may result in unauthorized access or use of your firearm by another. Obey all laws relating to the storage and transportation of firearms. Your local police department or gun shop can furnish you with available information on storing and/or transporting a firearm safely and legally.

- **YOUR FIREARM IS YOUR RESPONSIBILITY.** You must prevent your firearm from being stolen or from being used by untrained or unqualified individuals. Keep it locked, unloaded and secured when not in use.

- Use the lock provided to prevent unauthorized use, follow the instructions supplied with the lock.

- Never leave the key with the stored firearm.

PREPARATION FOR FIRING

WARNING:THE FAILURE TO FOLLOW THESE FIREARM SAFETY REQUIREMENTS WILL CAUSE SERIOUS PERSONAL INJURY OR DEATH TO YOU OR OTHERS.

- **ALWAYS TREAT ALL FIREARMS AS IF THEY WERE LOADED.**
- **ALWAYS BE SURE THAT ALL CYLINDERS AND ACTIONS OF FIREARMS ARE OPEN, THAT CHAMBERS ARE CLEAR OF CARTRIDGES OR SHELLS, MAGAZINES ARE REMOVED OR UNLOADED, AND THAT FIREARMS ARE POINTING IN A SAFE DIRECTION.**
- **ALWAYS WEAR ADEQUATE AND PROPER EAR PROTECTORS SPECIFIED FOR FIREARM USE** to prevent permanent damage to your hearing. Make sure others who are nearby are wearing ear protection as well.
- **ALWAYS WEAR SAFETY GLASSES SPECIFIED FOR FIREARM USE,** whether indoors or out. Safety glasses should protect your eyes from the firing flash and particles associated with the discharge of ammunition. Failure to do so creates a risk of personal injury from particle or debris spitting or ricochets.
- **ALWAYS BE ALERT AND ALWAYS FOLLOW THE SAFETY INSTRUCTIONS OF THE RANGE OFFICER.** Never shoot if you are tired, cold or impaired in any way.
- **ALWAYS BE AWARE OF OTHER PEOPLE** so that persons cannot accidentally walk into the line of fire.
- **THE SHOOTER (AND ALL OTHERS IN THE SHOOTING AREA) MUST ALWAYS BE IN A POSITION THAT IS OUT OF THE LINE OF FIRE** and are not within an area where they may be struck by a ricochet or particles ejected from a firearm, or by ejected cases from other types of firearms.
- **NEVER SHOOT AT HARD SURFACES,WATER OR RANDOMLY INTO THE SKY.** Always select a place to shoot that has a safe backstop and is free from obstructions and water surfaces which cause ricochets.
- **NEVER USE ALCOHOL OR DRUGS BEFORE OR WHILE SHOOTING OR HANDLING ANY FIREARM.**

AMMUNITION

WARNING: NEVER USE AMMUNITION NOT SPECIFICALLY DESIGNATED FOR USE IN YOUR FIREARM. FAILURE TO USE THE CORRECT TYPE OR CALIBER OF AMMUNITION MAY CAUSE THE FIREARM TO JAM, FAIL TO FIRE OR EVEN GENERATE EXCESSIVE PRESSURE WHICH CAN DAMAGE OR EVEN RUPTURE YOUR FIREARM, CAUSING PERSONAL INJURY, DEATH OR PROPERTY DAMAGE.

Locate the cartridge designation marked on the firearm. This information indicates the correct ammunition that must be used in this firearm. (Figure 1).

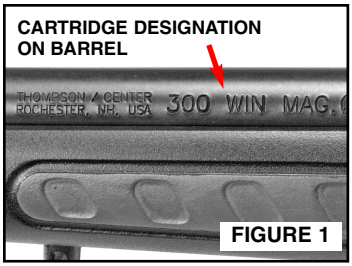


FIGURE 1

You are responsible for selecting ammunition that meets industry standards and is appropriate in type and caliber for this firearm.

Never use a cartridge not specifically designated for use in your firearm. The wrong type of ammunition may exceed the capability of your firearm and may damage or even rupture your firearm.

Never mix ammunition.

In some cases, a round of ammunition not specified on your firearm may fit into the chamber. Firing ammunition not specified on your firearm may cause it to rupture and cause serious injury or death to you or others.

Always inspect your ammunition before using it. Never use dirty, corroded or damaged ammunition which can lead to a burst cartridge which may cause damage to the firearm and personal injury or death.

Use only commercially manufactured ammunition with internal ballistic pressures which are in strict accordance with the specifications of the Sporting Arms and Ammunition Manufacturers' Institute (SAAMI). If you are uncertain, contact your ammunition supplier for verification.

WARNING: NEVER USE NON-STANDARD, RELOADED OR "HANDLOADED" AMMUNITION WHICH HAS NOT BEEN SUBJECTED TO INTERNAL BALLISTIC PRESSURE TESTING. RELOADED OR HANDLOADED AMMUNITION, MAY HAVE MANY MANUFACTURING AND QUALITY VARIABLES (SUCH AS THE TYPE AND AMOUNT OF GUN POWDER). ANY AMMUNITION THAT IS IMPROPERLY MANUFACTURED, EVEN IN THE SLIGHTEST DEGREE, MAY FAIL TO FIRE OR MAY GENERATE EXCESSIVE INTERNAL PRESSURES WHICH CAN DAMAGE OR EVEN RUPTURE THE FIREARM, CAUSING PERSONAL INJURY OR DEATH TO THE SHOOTER OR THOSE IN THE IMMEDIATE VICINITY.

A firearm and ammunition are a system and must work together. There are different types of ammunition for different types of firearms. Your firearm has been designed for ammunition of a specific type and a specific gauge or caliber. It is important to select the proper ammunition for your firearm.

Different combinations of bullet velocity, bullet weight and firearm weight can have major impact on felt recoil; high felt recoil can be uncomfortable to some shooters.

WARNING: NEVER USE CARTRIDGES OR SHELLS OTHER THAN THOSE DESIGNATED BY THE MARKING ON THE BARREL. DOING SO CAN RESULT IN DANGEROUSLY HIGH PRESSURES THAT MAY DAMAGE THE FIREARM AND POSSIBLY CAUSE SERIOUS INJURY TO YOURSELF AND OTHERS.

WARNING: DEATH, SERIOUS INJURY AND DAMAGE CAN RESULT FROM THE USE OF INCORRECT AMMUNITION OR BORE OBSTRUCTIONS.

MODEL AND FEATURES IDENTIFICATION

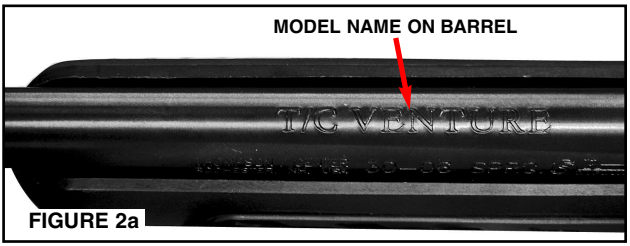
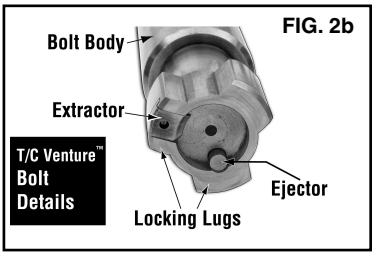
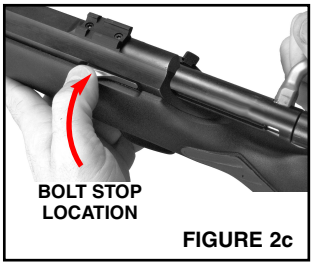
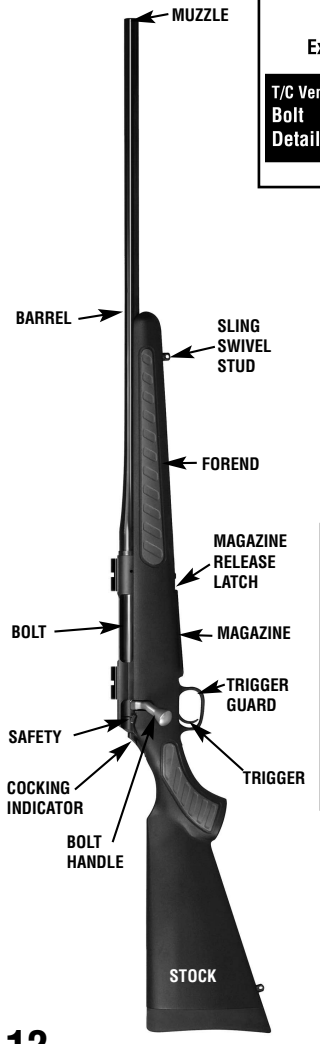
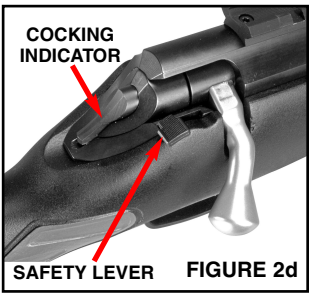


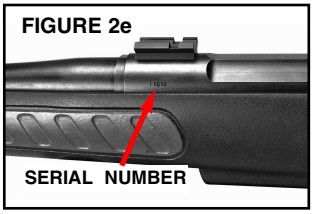
FIGURE 2a











INSPECTING AND INITIAL ASSEMBLY

WARNING: ALWAYS ENSURE THAT THE FIREARM IS UNLOADED BEFORE INSPECTING OR ASSEMBLING AND ALWAYS KEEP THE MUZZLE POINTED IN A SAFE DIRECTION.

Your Thompson/Center VENTURE™ rifle comes completely assembled from the factory except for the bolt, which has been removed for transportation and storage. The bolt is packed separately in the shipping carton.

INSPECT

- Grasp the rifle, keeping your finger outside the trigger guard and off the trigger, point the muzzle in a safe direction.
- Check to be certain that the chamber is empty (Figure 3).
- Ensure that the magazine is empty (Figure 4).
- Press the magazine latch rearward to release the magazine (Figure 5).
- Orient the rifle as shown in the following photos to allow the magazine to drop out of the rifle when the magazine latch is released (Figure 6)..

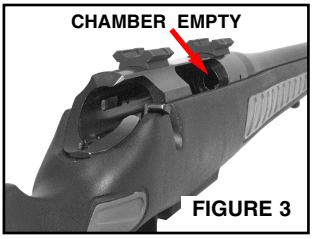


FIGURE 3

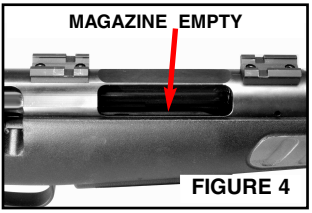


FIGURE 4

FIGURE 5

FIGURE 6

INSTALLING THE BOLT

- Grasp the bolt by its handle and slide the bolt forward into the receiver as shown (Fig 7).
- Rotate the bolt handle upward (Figure 8) until the bolt stop engages the groove in the bolt itself.
- Push the bolt fully forward into the receiver once the handle is in this position.
- Close the bolt by turning the bolt handle down (Figure 9).

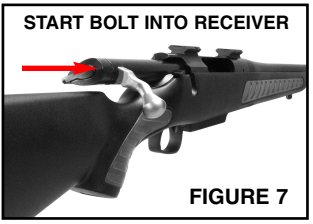


FIGURE 7

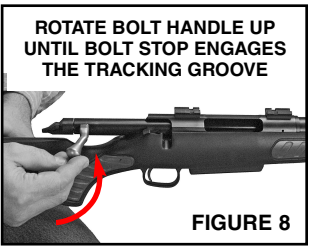


FIGURE 8

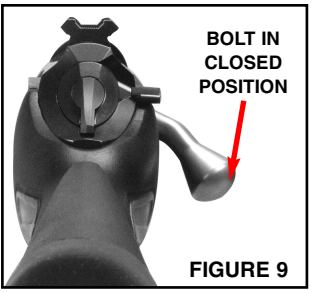


FIGURE 9

The Safety Lever

- Located on the right side at the rear of the receiver, it has two positions that are set by the user:
- Fully rearward - In the "SAFE" position (Figure 10).
- Fully forward in the - "FIRE" position (Figure 11) where the red dot on the stock is now visible and the gun can be fired by pulling rearward on the trigger.

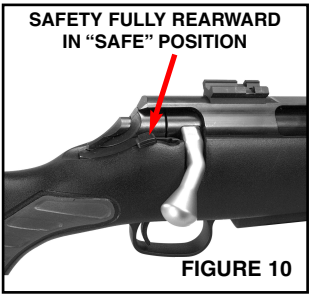


FIGURE 10

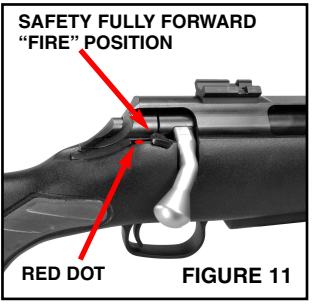


FIGURE 11

WARNING: NEVER RELY ON MECHANICAL FEATURES ALONE. ONLY YOUR SAFE GUN HANDLING WILL ENSURE THE SAFE USE OF YOUR FIREARM. THIS IS YOUR RESPONSIBILITY.

WARNING: NEVER MODIFY ANY OF THE PARTS IN YOUR FIREARM. DO NOT ADD OR REPLACE ANY OF THE PARTS IN YOUR FIREARM UNLESS THEY ARE GENUINE THOMPSON/CENTER PARTS AND YOU FOLLOW THE INSTRUCTIONS SUPPLIED BY THOMPSON/CENTER. IF YOU DO OTHERWISE, IMPROPER FUNCTIONING MAY OCCUR AND SERIOUS INJURY OR DEATH MAY RESULT.

LOADING

WARNING: ALWAYS POINT THE MUZZLE IN A SAFE DIRECTION.

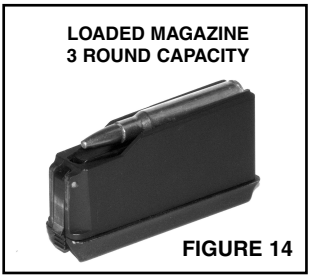


FIGURE 14

- Open the bolt and inspect the bore for obstructions (and clean if necessary).
- Keep your finger outside the trigger guard and off the trigger, point the muzzle in a safe direction.
- Do not load the rifle until you have read and fully understand this manual.
- Do not load the rifle until you are ready to use it.
- Never load your rifle until you are sure of your target, what is beyond it and are fully prepared to fire.
- Place the safety lever in the “SAFE” position (Fig 15).
- Remove the magazine from the rifle in order to load the cartridges into it. Insert the cartridges into the magazine as shown (Figure 14).
- Just prior to firing, open the bolt fully and then insert the loaded magazine and “snap” it into place - tipping the back in first and then lifting the front until it “clicks” into locked position (Figure 17).

FIGURE 15

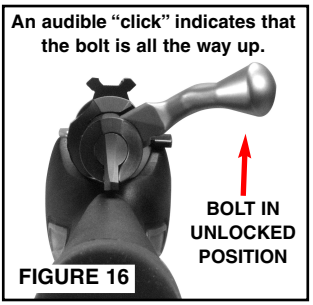


FIGURE 16

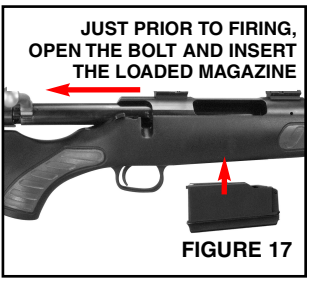


FIGURE 17

WARNING: NEVER CARRY THIS RIFLE WITH A CARTRIDGE IN THE CHAMBER. FAILURE TO FOLLOW THIS INSTRUCTION CAN LEAD TO PERSONAL INJURY OR DEATH TO YOU OR OTHERS.

FIRING

WARNING: ALWAYS KEEP THE MUZZLE POINTED IN A SAFE DIRECTION.

WARNING: WEAR EYE AND EAR PROTECTION SPECIFIED FOR FIREARM USE EVERY TIME YOU DISCHARGE YOUR FIREARM. MAKE SURE OTHERS IN THE VICINITY OF WHERE YOU WILL BE SHOOTING DO SO AS WELL.

- Make certain that the safety is in the “SAFE” position.
- Close the bolt to strip a round from the magazine and put it into the chamber (Figure 18).
- Grasp firearm with one hand on the fore-end and other hand on the grip with the trigger finger resting along and outside of the trigger guard. Raise firearm and pull buttstock firmly into shoulder.
- Push the safety lever to the fully forward “FIRE” position (Figure 19).
- The rifle will now fire when pressure is applied to the trigger.

PLACE SAFETY IN THE “SAFE” POSITION - THEN CLOSE BOLT

FIGURE 18

SAFETY FULLY FORWARD IN THE “FIRE” POSITION

FIGURE 19

- Place your finger on trigger and pull it until the rifle fires.
- You may continue to fire by fully opening and closing the bolt and pulling the trigger until the rifle is empty.
- To reload, see the **Loading Section.**

CLEARING MISFIRES

WARNING: IF YOUR FIREARM GIVES ANY INDICATION THAT IT IS NOT PERFORMING PROPERLY OR THE OPERATION OF YOUR FIREARM HAS CHANGED "THE WAY IT FEELS OR SOUNDS", STOP FIRING. MAKE SURE THE FIREARM IS POINTED IN A SAFE DIRECTION, UNLOAD THE FIREARM AND HAVE IT INSPECTED BY A FACTORY TECHNICIAN. CALL THOMPSON/CENTER CUSTOMER SUPPORT.

- If a cartridge fails to fire, keep the muzzle pointed in a safe direction and wait 10 seconds before opening the bolt and ejecting the suspect cartridge. Then remove the magazine and make sure that the rifle is unloaded.

UNLOADING

WARNING: ALWAYS KEEP THE MUZZLE POINTED IN A SAFE DIRECTION.

- Open the bolt and ensure that the chamber is empty (Figure 20).
- Set safety lever to the "SAFE" position (Fig. 21).
- Press the magazine latch rearward and remove the magazine (Figure 23).

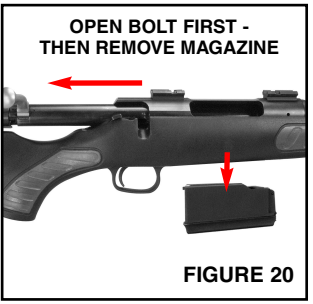


FIGURE 20

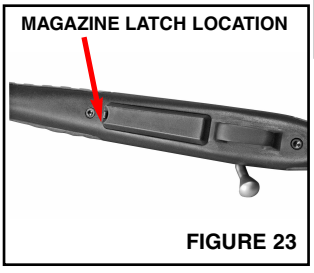


FIGURE 23

FIGURE 21

FIGURE 24

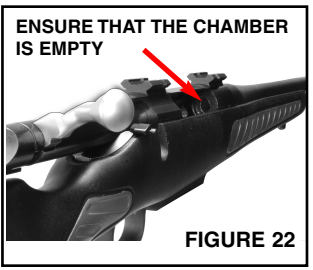


FIGURE 22

DISASSEMBLY - FIELD STRIPPING

WARNING: ALWAYS KEEP THE MUZZLE POINTED IN A SAFE DIRECTION.

WARNING: NEVER DO ANYTHING BEYOND WHAT YOU ARE SPECIFICALLY INSTRUCTED TO DO IN THIS MANUAL. NEVER ALTER OR MODIFY THE PARTS IN YOUR FIREARM.

WARNING: WEAR SAFETY GLASSES EVERY TIME YOU ASSEMBLE OR DISASSEMBLE YOUR FIREARM.

WARNING: DO NOT ALTER, MODIFY OR REPLACE ANY OF THE PARTS OF YOUR FIREARM UNLESS THIS WORK IS PERFORMED BY A QUALIFIED GUNSMITH USING GENUINE THOMPSON/CENTER PARTS. IF YOU DO OTHERWISE, IMPROPER FUNCTIONING MAY OCCUR AND SERIOUS INJURY MAY RESULT.

- Ensure that the magazine and chamber are empty.

REMOVAL OF BOLT

- Lift the bolt handle and draw the bolt fully to the rear.
- Place the safety lever in the "SAFE" position.
- Check through the ejection port to confirm that the chamber and magazine are both unloaded.
- At this point, press the bolt stop in as shown (Figure 25).
- Continue to hold the bolt stop depressed while you remove the bolt from the receiver with a gentle pull rearward (Figure 26) taking care not to hit the stock - causing cosmetic damage.

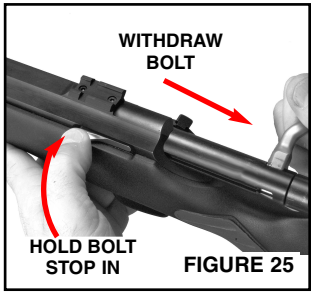


FIGURE 25

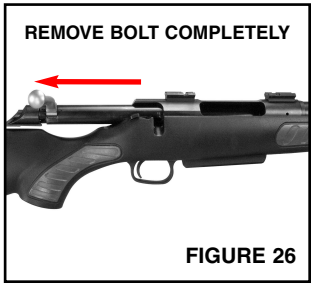


FIGURE 26

SCOPE MOUNT

WARNING: ALWAYS ENSURE THAT THE FIREARM IS UNLOADED BEFORE INSTALLING A SCOPE OR ANY OTHER ACCESSORIES. FAILURE TO DO THIS CAN CAUSE PERSONAL INJURY OR DEATH TO YOU OR OTHERS.

We recommend that you have a competent gunsmith install your scope and mount.

Follow the instructions supplied with the scope and rings to ensure proper eye relief

FIGURE 27

The T/C VENTURE is factory equipped with a Weaver-style scope mount bases. These bases accept a ring and scope combination of your choice. Different scopes have varying lengths of recommended eye relief. You need to choose a combination that allows for adequate clearance between the scope and your eye brow. Follow the instructions supplied with the scope and rings for proper installation (Figure 27).

WARNING: A SCOPE WHICH IS NOT SECURELY MOUNTED MAY BECOME DETACHED UPON RECOIL OF THE FIREARM. IF IT BECOMES DETACHED IT MAY FLY BACK AND STRIKE THE SHOOTER OR A BYSTANDER AND CAUSE INJURY. OBSERVE THE CONDITION OF ALL THE SCOPE MOUNT SCREWS AFTER FIRING. IF THE MOUNTING SCREWS SHOW SIGNS OF LOOSENING DO NOT FIRE THE GUN AGAIN; TAKE IT TO A QUALIFIED GUNSMITH FOR ASSISTANCE.

MAKING TRIGGER ADJUSTMENTS

WARNING: ALWAYS ENSURE THAT THE FIREARM IS UNLOADED BEFORE ADJUSTING THE TRIGGER OR DRY FIRING.

NOTE: The T/C VENTURE trigger pull is user adjustable for weight of pull. The trigger pull has been set at the factory with proper over-travel and sear engagement.

- After determining that the firearm is unloaded proceed as follows:
- Trigger "Weight of Pull" adjustment can be made by first removing the bolt from the receiver to gain access to the adjustment screw (Figure 28).
- Turn the screw clockwise (as viewed from the top of the rifle) to increase the trigger pull force required. A trigger adjustment tool is provided with the T/C VENTURE rifle (Figure 29).
- Turn the adjustment screw counter-clockwise to decrease the trigger pull force required.

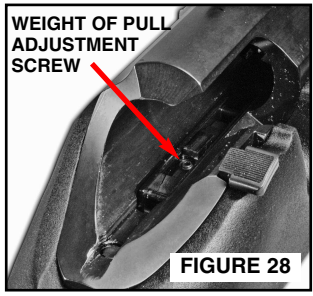


FIGURE 28

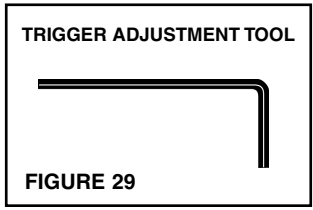


FIGURE 29

- After each adjustment, with the chamber empty and the rifle pointed in a safe direction, dry fire the rifle until the desired pull is achieved.
- Do not attempt any other trigger adjustments.

Dry Firing Note

- Be certain that the chamber is unloaded and the magazine is removed from the rifle. Keep the firearm pointed in a safe direction. The Thompson/Center VENTURE rifle can be dry fired without damage to the firing pin or other components. To dry fire, cock the rifle by lifting the bolt handle fully and returning it to the closed position and then pulling the trigger.

CLEANING AND MAINTENANCE

WARNING: ENSURE THAT YOUR FIREARM IS UNLOADED BEFORE BEGINNING TO CLEAN IT. (SEE "INSPECTING YOUR FIREARM" SECTION). ALWAYS FOLLOW THE FUNDAMENTAL NRA RULES OF SAFE GUN HANDLING.

WARNING: WEAR EYE PROTECTION SPECIFIED FOR FIREARM USE EVERY TIME YOU CLEAN OR MAINTAIN YOUR FIREARM.

- Before using your firearm for the first time, it should be cleaned.
- Your firearm was treated at the factory with either a preservative or oil to protect it against corrosion during shipping and storage.
- Preservative and oil should be wiped from the bore, chamber and exposed areas using a clean swab or patch before using the firearm.

CAUTION:
Never disassemble your firearm beyond the instructions in the Field Stripping and Inspection sections of this manual.

- Purchase cleaning supplies from your firearms dealer that are specifically designated for your type and caliber of firearm. Many suppliers offer these in kit form for your convenience.

* Follow the instructions provided with your cleaning supplies.

* Remove excessive firing residue from the bore and chamber using a properly fitted brush.

* Clean the exterior of the firearm using a non-abrasive cleaning cloth.

* After cleaning, lightly coat the metal parts, internal and external with a gun oil.

Whenever your firearm has been exposed to sand, dust, extreme humidity, water or other adverse conditions, it must be cleaned and lubricated.

WARNING: DISCHARGING FIREARMS IN POORLY VENTILATED AREAS, CLEANING FIREARMS OR HANDLING AMMUNITION MAY RESULT IN EXPOSURE TO LEAD AND OTHER SUBSTANCES KNOWN TO CAUSE BIRTH DEFECTS, REPRODUCTIVE HARM AND OTHER SERIOUS PHYSICAL INJURY. HAVE ADEQUATE VENTILATION AT ALL TIMES. WASH HANDS THOROUGHLY AFTER EXPOSURE.

- Run a few patches saturated with good quality gun cleaning solvent through the bore, preferably from the chamber end to avoid damage to the rifling at the muzzle. Use of a bronze bore brush may be required periodically. More extensive cleaning, especially after the T/C VENTURE has been subjected to rain or snow, would include wiping all of the external metal surfaces with a dry cloth, followed by a light coating of oil. Further disassembly of your T/C VENTURE is not recommended. If the internal components require cleaning, it is recommended that you return the gun to Thompson/Center's Service Department.

CAUTION:
Always follow the instructions provided with your gun cleaner and gun lubricant.

CAUTION:
Some cleaners can cause damage to your firearms. You should avoid prolonged solvent immersion and prolonged ultrasonic cleaning of your firearm. Choice of solvent should be restricted to those products specifically developed for firearms maintenance. Damage to a firearm's finish may occur if these cautions are ignored. Ammoniated solvents or other strong alkaline solvents, should not be used on any Thompson/Center firearm. As a rule of thumb, if you would be comfortable applying the solvent of your choice to the finish of your automobile, it will probably be safe for use on your firearm.

WARNING: NEVER MANIPULATE, ADJUST OR CHANGE ANY OF THE INTERNAL COMPONENTS OF YOUR FIREARM UNLESS SPECIFICALLY DIRECTED TO DO SO IN THIS MANUAL. IMPROPER MANIPULATION OF ANY INTERNAL COMPONENT MAY AFFECT THE SAFETY AND RELIABILITY OF YOUR FIREARM AND MAY CAUSE SERIOUS INJURY OR DEATH.

WARNING: ANY MAINTENANCE OR SERVICE NOT SPECIFIED IN THIS MANUAL MUST BE PERFORMED BY A QUALIFIED GUNSMITH USING GENUINE THOMPSON/CENTER PARTS. IF YOU DO OTHERWISE, IMPROPER FUNCTIONING OF YOUR FIREARM MAY OCCUR AND SERIOUS INJURY OR DEATH MAY RESULT.

Do not use heavy (thick) grease or oil as during cold weather this type of lubricant may congeal and slow or stall the interaction of parts - creating a potentially dangerous condition.

MAINTENANCE BEFORE STORAGE
When storing, do not encase your firearm in anything that will attract or hold moisture, for example, leather or heavy cloth. Also, do not store guns with a plug inserted in the barrel for this can be a contributing factor to moisture accumulation. If your firearm is to be stored for an extended period, the bore, chambers and internal working mechanism should be oiled with a high quality lubricating oil or preservative intended for firearms. The external working mechanisms, lower and upper receiver, and barrel should be coated with an anti-rust oil. Before using your firearm again, be sure to clean it. Every time you clean your firearm, check it for signs of wear. If wear is noted, do not use the firearm. Return it to Thompson/Center for service or have it checked by a qualified gunsmith.

LIMITED LIFETIME WARRANTY

This warranty is granted by Thompson/Center Arms Company, Inc. This warranty, which shall last for the Lifetime of the original owner of any factory finished firearm, is established by the return of the Thompson/Center Arms authorized warranty card within thirty (30) days of purchase of such firearm. With respect to such firearm, this warranty supersedes any and all other warranties.

Thompson/Center Arms firearms are warranted to be free from defects in material and workmanship. Any such defects of which Thompson/Center Arms receives written notice by the original owner will be remedied by Thompson/Center Arms without charge within a reasonable time after such notification and delivery of the firearm as provided below.

Warranty claims (in writing) and the firearm or part thereof concerned should be delivered, postage prepaid, to the factory at Thompson/Center, 400 North Main Street, Rochester, New Hampshire, 03867. In addition, a copy of the bill of sale in the owner's name, or, where applicable, a copy of ATF Form 4473 indicating date of purchase must be included. It is important that the owner comply will all applicable federal, state and local laws and regulations in the shipment of firearms to Thompson/Center Arms.

Warranty claims should state the model and, where applicable, the serial number of the firearm concerned and the description of the difficulty experienced. It is recommended that shipments be insured by the owner, since Thompson/Center Arms will accept no responsibility for loss or damage in transit. Transportation and insurance charges for return to the owner will be paid by Thompson/Center Arms if the claim is covered by this warranty.

UNDER NO CIRCUMSTANCES SHALL THOMPSON/CENTER ARMS BE RESPONSIBLE FOR INCIDENTAL OR CONSEQUENTIAL DAMAGES WITH RESPECT TO ECONOMIC LOSS, INJURY, DEATH OR PROPERTY DAMAGE, WHETHER AS A RESULT OF BREACH OF THIS WARRANTY, NEGLIGENCE OR OTHERWISE.

Some States do not allow the exclusion or limitation of incidental or consequential damages, so the above limitation or exclusion may not apply to you.

Thompson/Center Arms will not be responsible for:

Defects or malfunctions resulting from careless handling, unauthorized adjustments or modifications made or attempted by anyone other than a qualified gunsmith following Thompson/Center Arms authorized procedures, or failure to follow the instructions in the Thompson/Center Arms Safety & Instruction manual.

Use of defective or improper ammunition and/or propellant, corrosion, neglect, abuse, ordinary wear and tear, or unreasonable use.

Use of replacement parts, including but not limited to barrels and springs, other than Thompson/Center Arms factory or authorized parts.

Criminal misuse, negligence, or use under the influence of drugs or alcohol.

Services performed by the Thompson/Center Arms Custom Shop and/or Repair Department do not void this warranty. This warranty gives you specific legal rights, and you may also have other rights which vary from State to State.

Note: All liability is excluded in the event that the instructions in the Thompson/Center Arms Safety and Instruction manual are not observed.

CONTACT & SHIPPING FOR SERVICE

Thompson/Center Shipping Address:
Thompson/Center
400 North Main St.
Rochester, New Hampshire 03867

Should your Thompson/Center firearm require service, it should be returned to the Thompson/Center factory.

- Call or e-mail the Customer Service Dept. for authorization and shipping instructions.
- Ensure that the magazine and chamber are unloaded.
- **Do not attempt to ship a firearm via US Postal Service; only federally licensed dealers may ship a firearm by US Postal Service.**
- **DO NOT SHIP ANY AMMUNITION.**
- Enclose a letter which includes your full name and address (no P.O. Boxes, please), daytime telephone number, e-mail address, the serial number of the firearm, and details of the problem experienced (stating the brand and type of ammunition used when the problem occurred) or work desired.
- Record the serial number before shipping, in case you wish to check on the repair status of your firearm.
- Please remove all custom parts and accessories, such as stocks, special sights and scopes, or slings from your firearm before returning.
- Place the firearm in its original case or in a similarly secure container and pack it securely.
- The package must **NOT** bear any markings which indicate the identity of the contents.
- It is most important that you comply with federal, state, and local laws and regulations. The following guidelines are meant to help, but you must seek assistance from the appropriate authorities if necessary.
- If your firearm must be replaced, it *may* be necessary to ship the replacement to a dealer rather than directly to you. You *may* be requested to furnish a signed FFL (Federal Firearms License) from your dealer in such an instance.

- Warranty repair work will begin upon receipt and examination of the firearm. In the case of repairs or work not covered by the warranty, a quotation covering the cost of the work plus shipping charges will be sent to you. Repairs or modification will begin upon receipt of payment.

WARNING: YOU MAY PURCHASE ACCESSORIES FOR YOUR THOMPSON/CENTER FIREARM. YOU MUST HAVE SOME OF THESE PARTS INSTALLED BY A GUNSMITH QUALIFIED TO PERFORM SERVICE ON THOMPSON/CENTER FIREARMS. NEVER ATTEMPT TO MODIFY YOUR FIREARM OR INSTALL REPLACEMENT PARTS IN YOUR FIREARM. ALWAYS USE A QUALIFIED THOMPSON/CENTER GUNSMITH EVEN IF THE REPAIR SEEMS SIMPLE.

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PATENT INFORMATION

The T/C Venture™ is covered by one or more of the following Patents: #5,615,507.

T/C Mailing Address:
(for questions & comments)
Thompson/Center Arms Company, Inc.
PO Box 5002
Rochester, New Hampshire 03866

T/C Shipping Address:
(for repairs or warranty work)
Thompson/Center Arms Company, Inc.
ATTN: Repair Department
400 North Main Street
Rochester, New Hampshire 03867

Web Address:
www.tcarms.com

Customer Service Phone:
603-330-5659